

Work Order ID 124418

124418

Page 1

September-11-14 12:05:17 PM

Item ID: D4635-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Ceiling Panel, LH
 Start Date: 9/22/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/22/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: NLS Date: 14-09-17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4635	E

100		0.00							
100	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								

105		0.00							
105	Dry Material								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 245 deg. F
 Time IN: 5:00 PM
 Time OUT: 6:00 PM

OCT 01 2014
 Per.....

DAS
 27
 9-89
 14/10/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00				27			

110

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

Thermoform as per Dwg. D4635-1 and Folio FTA147

Dwg. Rev. E

Folio Rev. 10

NOTE: Check moulds prior to using to ensure proper placement of add-ons.

Visually inspect for proper formation and texture

130

130

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Trim to Finished Dimensions

14/10/12

1

B14/10/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data											
Equip/Tooling											
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Dimensional Inspection Memo Fill out Inspection Sheet Rev A	0.00 0.00				DAS 27 14/10/23			
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00			DAS 16 9-89 14/6/23				
160 *160* Packaging Packaging Packaging	Packaging Memo	0.00 0.00				DAS 27 9-89 14/10/23			

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Equip/Tooling									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

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Page 4

14/10/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

September-11-14 12:05:16 PM

Page 1

Work Order ID: 124418

124418

Parent Item: D4635-1

D4635-1

Parent Item Name: Fwd Ceiling Panel, LH

Start Date: 9/22/14

Required Date: 9/22/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 12/11/08 DL IPP Rev. C Dwg Update
13/07/09 DL IPP Rev D Dwg Update, Material
Change 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	3,356.313	25.27	26			

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

**

DAS

27

9-89

Location

Loc Qty

Loc Code

MAT023

3356.31332

114459

229.26

123105

38

124501

543.5

m128668

181.35

m129014

102.33332

m129471

21.92

m129738

2239.95

26

14/10/12

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	124418
Description: LH Fwd Ceiling Panel		Part Number:	D4635-1
Inspection Dwg: D4635	Rev: E	Page 1 of 1	

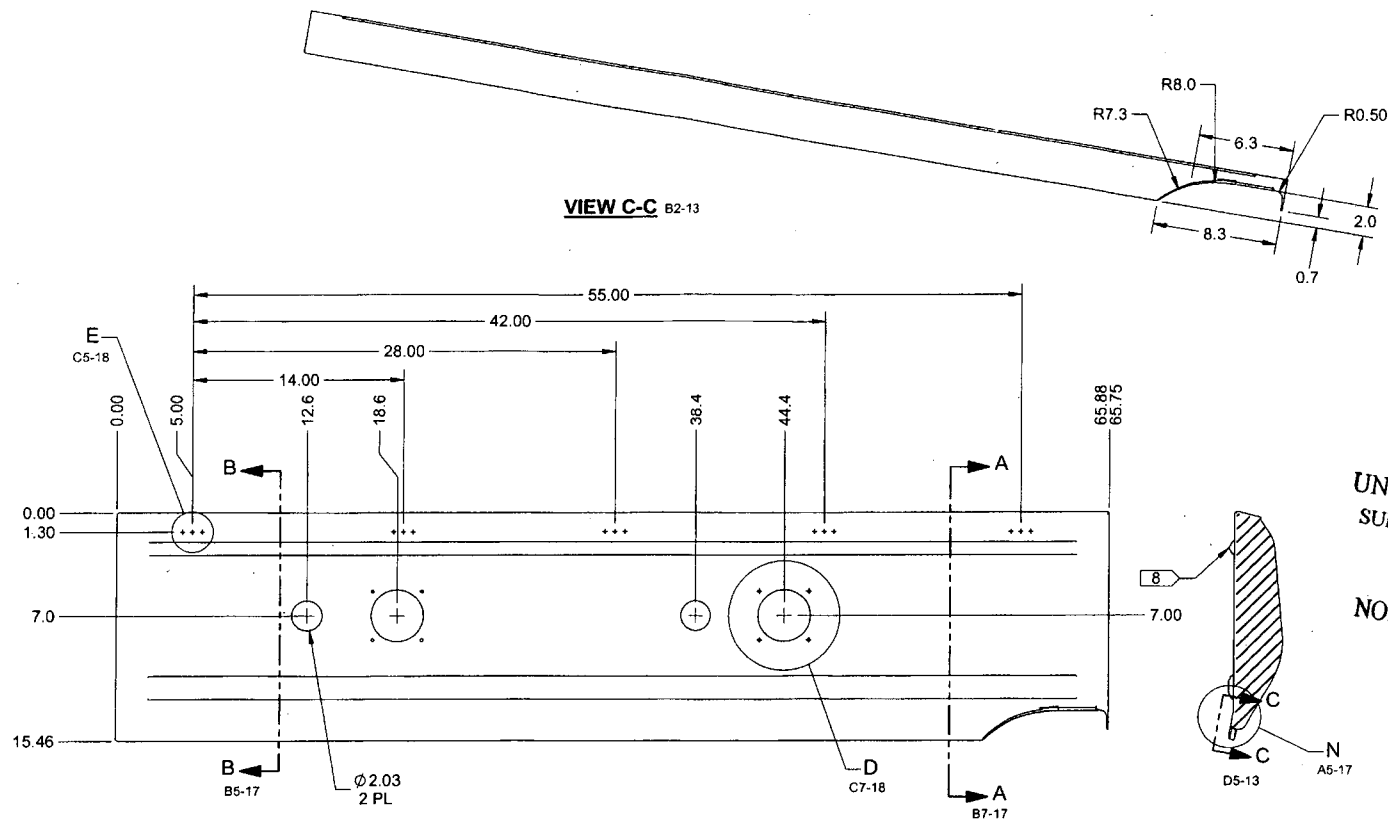
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.00	+/-0.030	14.00			th-01	
28.00	+/-0.030	28.00			th-01	
42.00	+/-0.030	42.00			ENC-09	
55.00	+/-0.030	55.00				
5.00	+/-0.030	5.00				
12.6	+/-0.100	12.6				
18.6	+/-0.100	18.6				
38.4	+/-0.100	38.4				
44.4	+/-0.100	44.4				
1.3	+/-0.100	1.3				
7.0	+/-0.100	7.0				
7.00	+/-0.030	7.00				
Ø2.03	+0.012/-0.001	2.041				
Ø0.191	+0.005/-0.001	0.194				
Ø3.50	+0.012/-0.001	3.553				
3.300	+/-0.010	3.300				
1.650	+/-0.010	1.650				
Ø0.129	+0.005/-0.001	0.1286				
1.300	+/-0.010	1.307				
0.650	+/-0.010	0.6491				
0.35 - 0.40	+/-0.030	0.374				
0.30	+/-0.030	0.311				
0.50	+/-0.030	0.501				

Measured by:	DAS 27	Audited by:	DAS 16	Preliminary Approval:	
Date:	11/10/23	Date:	9-89 04/06/23	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	

VIEW C-C B2-13



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124418 MJS
14-09-17

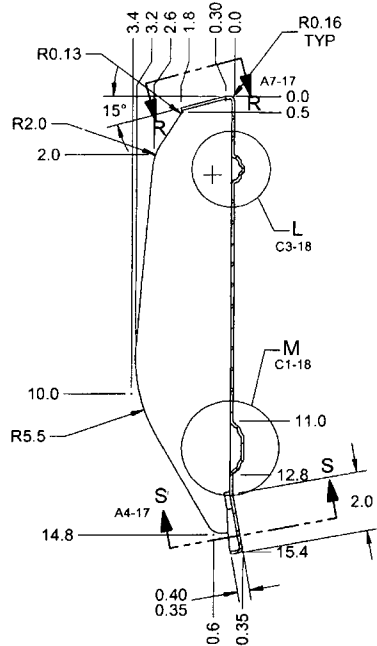
RELEASED
2014-01-22

NOTES:

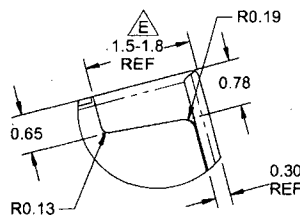
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.39 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-1 PER TOOL DT9839
- 10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-1 LH, FWD CEILING PANEL

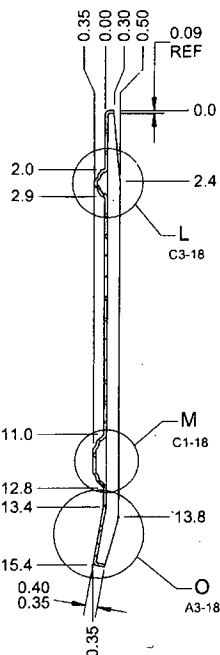
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DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4635	SHEET 13 OF 18
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	OUTBOARD CEILING PANELS	NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



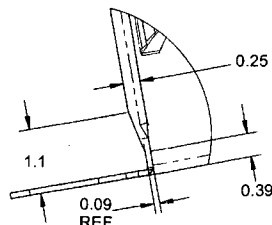
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SECTION A'-A' OPPOSITE B3-14
 SCALE 2X



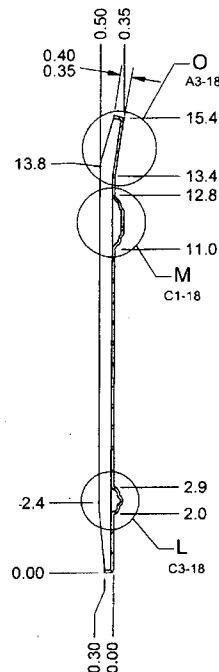
AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
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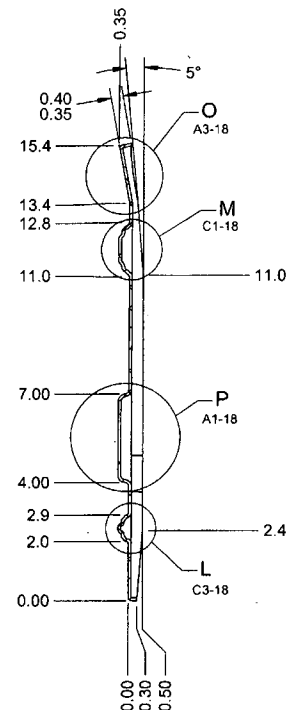
SECTION B-B B7-13
 SCALE 2X B7-14



AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
 SCALE 2X



SECTION G-G B4-15
 SCALE 2X B4-16

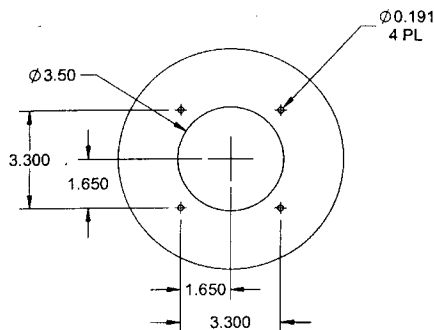


SECTION K-K C6-16
 SCALE 2X

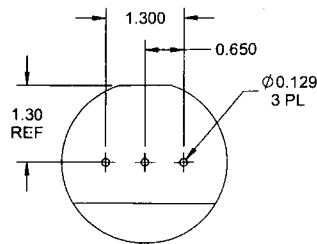
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DE APPR.	PC	DATE 14.01.09	
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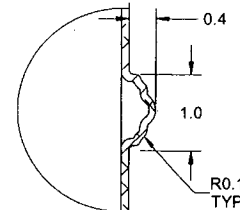
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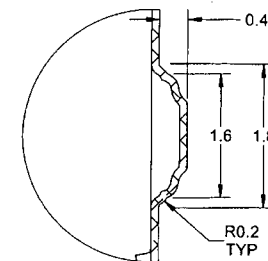
DETAIL D
SCALE 2X
B4-13
B3-14
B5-15
B5-16



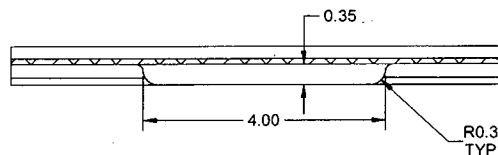
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C7-13
B6-14
C6-15
B5-16



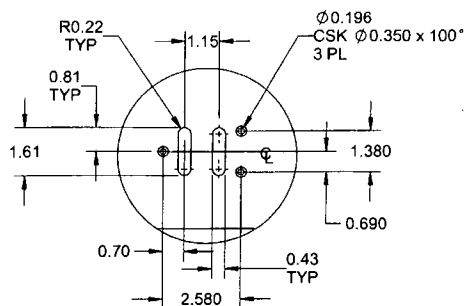
DETAIL I
SCALE 1.5X
B2-17
B4-17
C5-17
C7-17



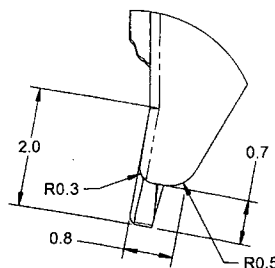
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SCALE 1.5X
C2-17
C3-17
C5-17
C7-17



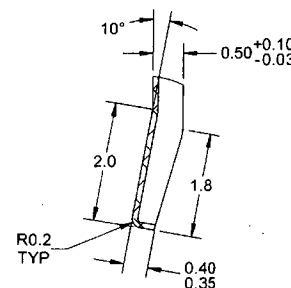
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SCALE 4X
B5-16



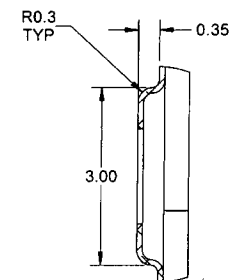
DETAIL Q
SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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8 7 6 5 4 3 2 1